

Split - 1

Date: Monday, 02/06/2008 8:11:12 AM
User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INNER AFT SADDLE
Job Number : 39621 -1	
Estimate Number : 11082	
P.O. Number :	Part Number : D5957
This Issue : 02/06/2008 S.O. No. :	Drawing Number : D5957 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 39606	Material :
Written By :	Due Date : 09/06/2008 Qty: 8 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:F ecn826 06.12.06 ec	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 Saddle Billet



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
D6101-007(7075-T7351)
Size 2.50" x 7.50" X 8.25" (Grain along 7.50")
Batch: *S.F 05/06/02*

2.0 HAAS3 HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

- 1-Machine as per folio D5957, Ensure Batch Number is entered
- 2-Machine Keyway
- 3-Deburr & Tumble *S.D 05/06/02*

3.0 QC1 INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET *S.F 05/06/02*

4.0 QC8 SECOND CHECK

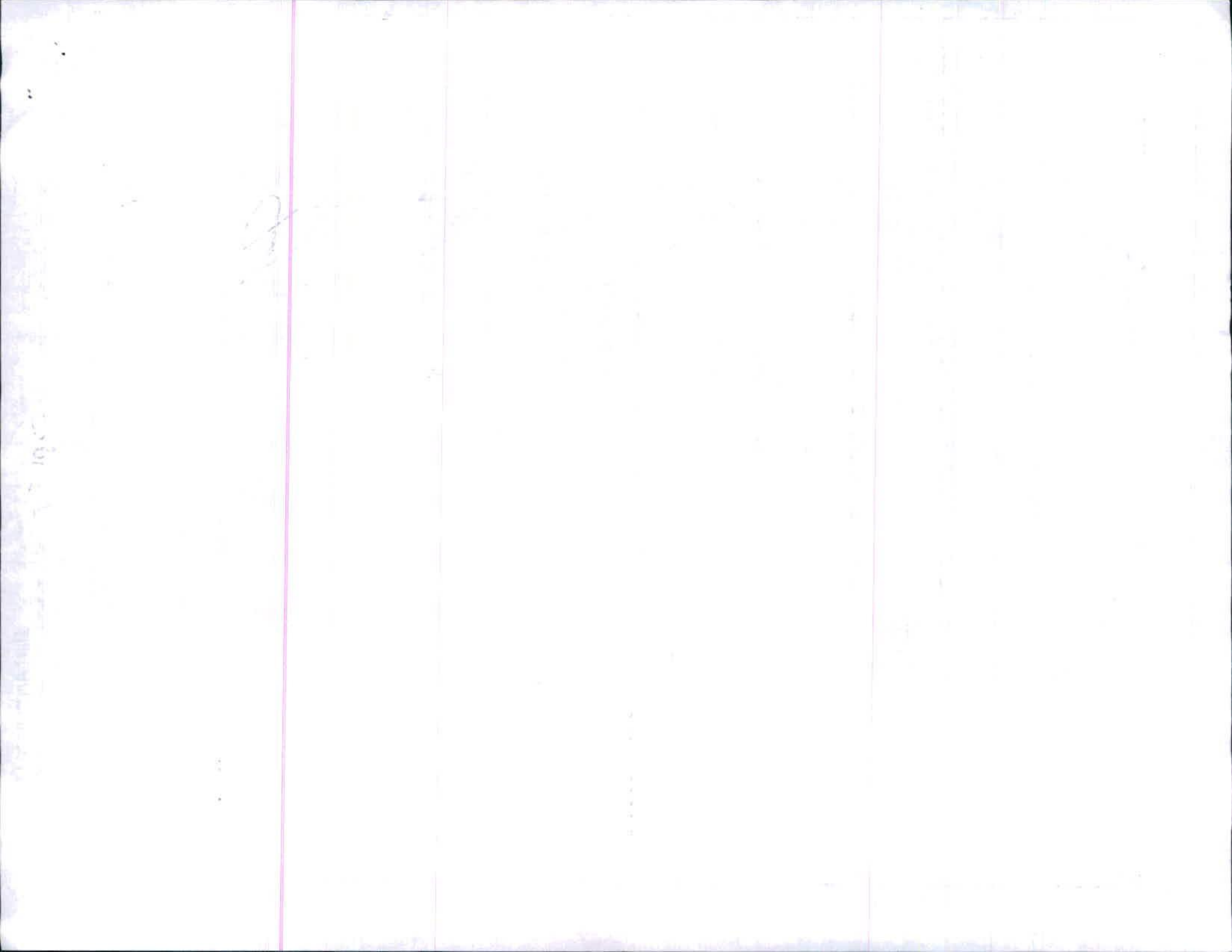


Comment: SECOND CHECK *S.D 05/06/02*

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1 *S.D 05/06/02*



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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

7:30

OVEN TEMPERATURE:

3:20°

FINISH TIME:

8:00

08-06-03

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

9.0

QC21

FINAL INSPECTION/W/O RELEASE

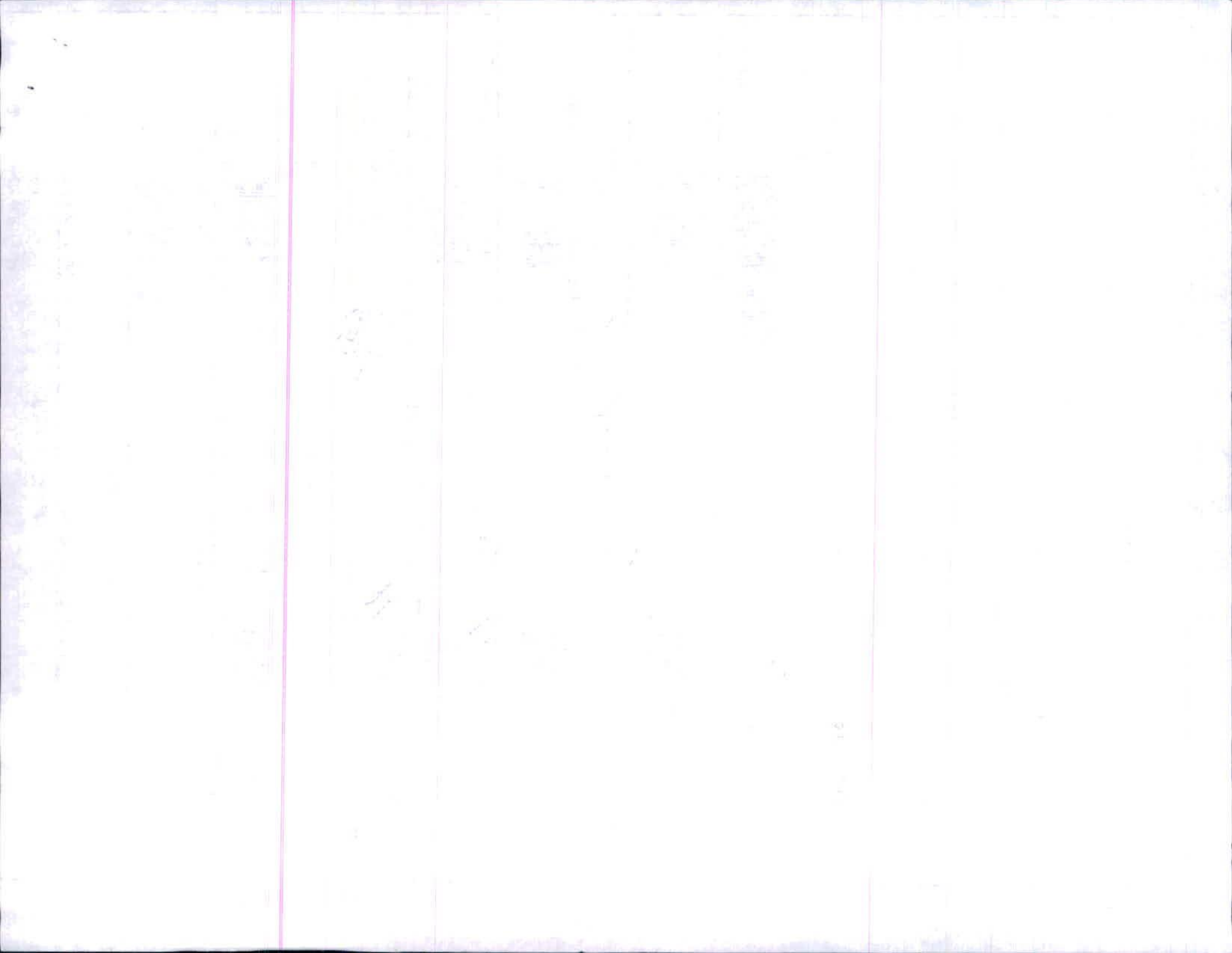


Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

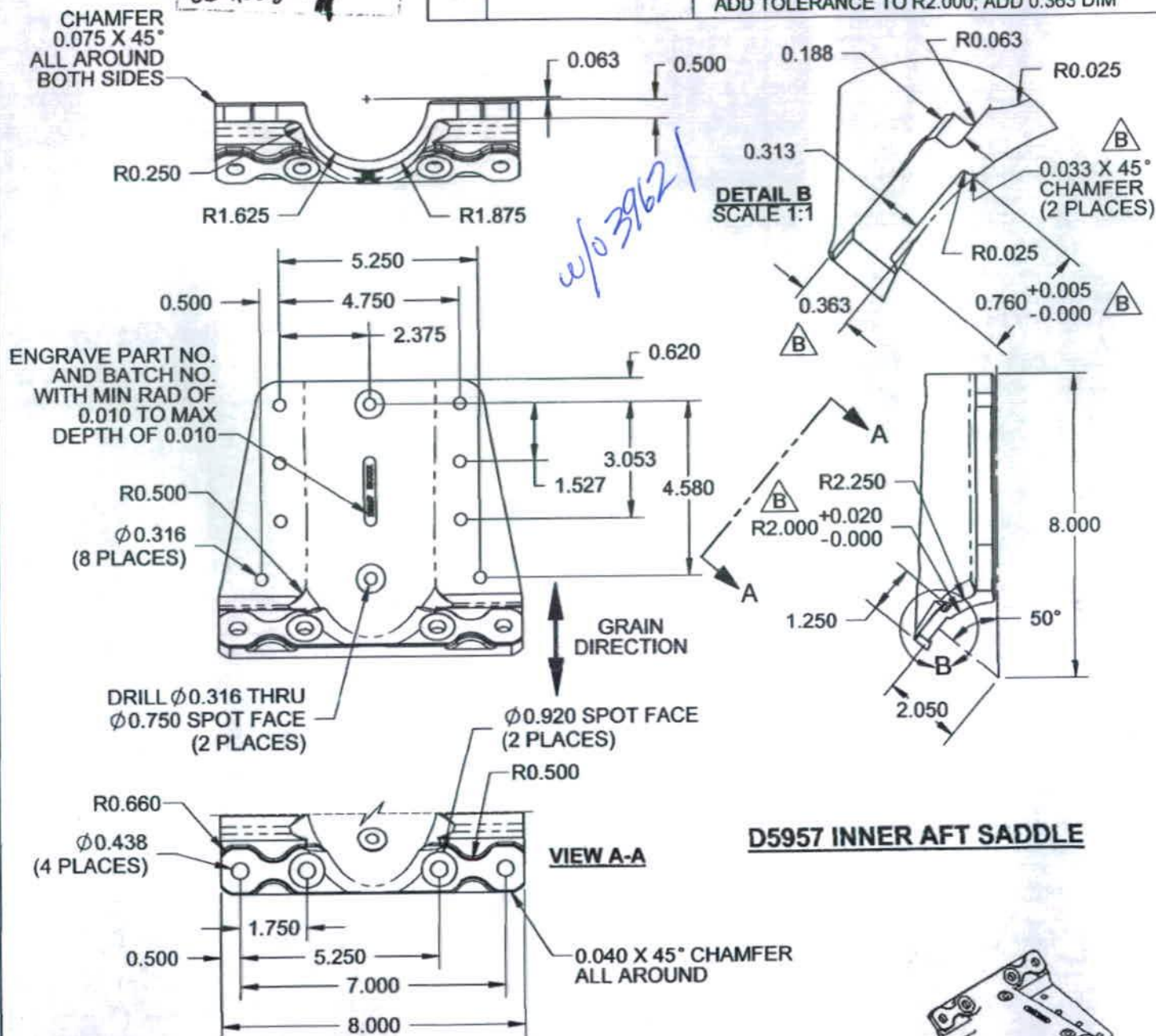


08-06-03



DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D5957	REV. B SHEET 1 OF 1
DATE 06.11.07	TITLE INNER AFT SADDLE SCALE 1:4		
REV A	DATE 97.05.06	DESCRIPTION NEW ISSUE	
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

ISOMETRIC VIEW
SCALE 1:8

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DART AEROSPACE LTD		Work Order: 39621	
Description: Inner Aft Saddle		Part Number: D5957	
Inspection Dwg: D5957		Rev: B	
		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.442					
B	1.745	1.755		1.748					
C	5.245	5.255		5.248					
D	6.995	7.005		6.998					
E	5.240	5.260		5.250					
F	4.745	4.755		4.750					
G	0.315	0.322		.319					
H	1.522	1.532		1.527					
I	3.048	3.058		3.052					
J	4.575	4.585		4.580					
K	0.313	0.318		.318					
L	0.495	0.505		.500					
M	0.490	0.510		.503					
N	1.865	1.885		1.878					
O	7.990	8.010		8.001					
P	2.240	2.260		2.250					
Q	0.307	0.312		.310					
R	0.760	0.765		.761					
S	0.490	0.510		.499					
T	1.625	1.645		1.634					
U	2.000	2.020		2.007					
V	0.023	0.043		.033					
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: RF
Date: 08/06/02

Audited by: [Signature]
Date: 01.06.02

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	
F	08.04.21	Dimension E revised	KJ/DD	

